



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D205-564-011
Job Sheet 184149



Part No: D205-564-011

Job Qty: 3 ea

Part Name: Bell Medium Bearpaws



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/3/18

Job Tracking No:

Due Date: 10/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV I SHEET 27 IPP F 00.01.20 Changed pick list, MPP 2019, CHG006 EC IPP Rev:G 06-08-28 As per Rev E JLM IPP Rev:H 08-01-11 Added Step #2 JLM Verified BY:EC IPP Rev:I 08-10-01 New Manufacturing Method JLM Verf By:EC IPP REV:J 15.06.05 as per ecn15-574/chg009 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	10/31/18	10/31/18	0.00	0.00	Start Up Stores/Pkg-1		NOV 12 2018
110	Packaging	3 pcs	10/31/18	10/31/18	0.00	0.00	Packaging1-2		DAS 4046 NOV 30 2018
120	QC	3 pcs	10/31/18	10/31/18	0.00	0.00	QC4		NOV 30 2018
130	Packaging	3 pcs	10/31/18	10/31/18	0.00	0.00	Packaging3-1		NOV 30 2018
135	DC	3 pcs	10/31/18	10/31/18	0.00	0.00	DC		18.11.30
140	QC21-FG	3 Ea	10/31/18	10/31/18	0.00	0.00	QC21		18.11.30

Part Op 130 - Identify and pack for shipping as per PPP D205-564-011 LOCATION: FG015
Descriptions: 135 - Photocopy blue file and type labels per PPP D205-564-011 CHG009

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-15A	Bolt	60 Ea (20 ea)	90-Start up Operation	5102730
D2274	Radius Block	60 Ea (20 ea)	90-Start up Operation	5129735
D2521	Individual Bearpaw	6 Ea (2 ea)	90-Start up Operation	5102730
D2529	Washer	60 Ea (20 ea)	90-Start up Operation	5102730
D3544-041	Clamp	12 Ea (4 ea)	90-Start up Operation	5104383x9 5113 54X3
D4060-1	Ski Clamp, Top	24 Ea (8 ea)	90-Start up Operation	5108554x3 5127840x2
D4061-1	Ski Cushion	24 Ea (8 ea)	90-Start up Operation	5153230x2 516007 8x22
MS21042L4	Nut	60 Ea (20 ea)	90-Start up Operation	5098597
NAS1149D0463J	Washer	60 Ea (20 ea)	90-Start up Operation	5092780

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-15A	60	558	0
	D2274	60	146	0
	D2521	6	7	0
	D2529	60	1,029	0
	D3544-041	12	37	0
	D4060-1	24	43	0
	D4061-1	24	258	0
	MS21042L4	60	4,903	0
	NAS1149D0463J	60	5,745	0

QQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐			
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Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition

Completed By _____
 _____ / Supervisor
 Verification _____
 Coordinator _____
 Approval _____
 DART Aerospace Ltd.
 1210 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL: 1-800-662-5200
 Email: sales@dartaero.com
 www.dartaerospace.com
 Container No: S126857
 Part: D205-564-011
 Job No: 184149
 Serial No/Batch: S126857
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: TC STC SH96-42 Issue AARFAH STC SR005711

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	FAULT CATEGORY Power ☐ Folio ☐ Grain ☐ Weld ☐ Wrong ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Wrong ☐ Dimensions ☐ Tolerance ☐ Cost ☐ Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____				

Part Specifications

Specifications could not be found.

Plex 10/3/18 11:03 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
Description Work Order Deviation		Disposition	
		Completed By	
		Lead hand / Supervisor Approval Verification	
		QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐							

5.0 PARTS LISTS

Note: Additional fasteners may be included depending on the configuration being installed.

5.1 Parts List Bearpaw Installation

(For Skidtubes equipped with Standard Wearplates)

Qty -011	Qty -013	Qty -015	Part Number	Description
X			D205-564-011	BEARPAW INSTALLATION
	X		D205-564-013	BEARPAW SKI INSTALLATION
		X	D205-564-015	SKI UPGRADE KIT
20	52	36	D2274	RADIUS BLOCK
2	2		D2521	BEARPAW
20	12	12	D2529	WASHER
4			D3544-041	CLAMP
	2	2	D3795-1	SKI FWD SECTION
	2	2	D3795-3	SKI MID SECTION
	2	2	D3796-041	FWD WEARPLATE
	2	2	D3796-043	AFT WEARPLATE
8	26	18	D4060-1	CLAMP (REPLACES D2947)
8	26	18	D4061-1	CUSHION (REPLACES D2182B055)
	8	8	AN4-12A	BOLT
20			AN4-15A	BOLT
	52	52	AN4-20A	BOLT
20	52	32	NAS1149D0463J	WASHERS (OR AN960JD416)
	8	8	AN970-4	WASHER
20	60	40	MS21042L4	NUT (OR MS21042-4)

5.2 Parts List Bearpaw Installation

(For Skidtubes equipped with Standard and Training Wearplates)

Qty -111	Part Number	Description
X	D205-564-111	BEARPAW INSTALLATION
20	D2274	RADIUS BLOCK
20	D2529	WASHER
4	D3544-041	CLAMP
6	D4060-7	CLAMP
2	D4060-9	AFT BEARPAW CLAMP
8	D4061-1	CUSHION
2	D5423-1	BEARPAW
16	AN4-20A	BOLT
20	AN4-22A	BOLT
20	NAS1149D0463J	WASHERS (OR AN960JD416)
20	MS21042L4	NUT (OR MS21042-4)

REFERENCE ONLY

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Revision: I

Date: 16.10.05

REFERENCE ONLY

REFERENCE ONLY

Change Record

PAGE 1 OF 1

Part Number: D205-564-011

Description: BEARPAW INSTALLATION

CHG #	DATE	BY	RELEVANT DOCUMENTS	ECN #
002	98.08.06	KE	D205-564 REV C, DSI 9108 REV A, D2771 REV A	
			D2182B060, D2274, D2521, D2522, D2529 (SS BOLT DESIGN)	
003	99.03.03	KE	D205-564 REV B	
			D2182B060 REV C, D2274, D2521, D2522, D2529 (BACK TO AN4 BOLTS	
			BUT w/ C'BORE ON TOP AND BOTTOM OF BEARPAW	
004	99.03.03	KE	SAME AS CHG 003 BUT w/ DEO 9143 REV A (NO TOP C'BORE	
			ON BEARPAW)	
005	99.11.01	KE	DR-D205-564 REV E, D205-564 REV B, DSI 9050 REV A, DSI 9058 REV D	
			DSI 9171 REV A, DEO 9143 REV A, D2182B060, D2521, D2529,	
			D2522-074 REV E, AN4-17A, AN960JD416, MS21042L4 (SAME AS CHG004	
			BUT w/ SHORTER CLAMP AND LONGER BOLTS PER DSI 9171)	
006	00.01.06	DS	D205-564 REV C (CHANGE TO D2946 CLAMPS & AN4-15A BOLTS)	
007	06.08.28	KJ	D205-564 REV E	
008	06.12.22	KJ	WAS K10015 CHG 002	
009	15.06.04	KJ	ICA-D205-564 REV 3, D4060 REV B, D4061 REV C	15-574

